

Work Order ID 38798-1

June 26, 2009 10:29:19 AM



Page 1

Item ID: D2304

Accept



Setup Start



Revision ID: B

Stop



Item Name: Aspirator Assembly

Start Date: 15/07/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 15/07/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *my*
QC:

Date: 15/7/09
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2304

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2304

SB 10/10/07

(3)

#105

inspect QCS

Identify as per dwg & Stock Location

160

0.00



Packaging

Memo

0.00

Packaging

#106 QCS final inspection

8/10/07

(73)

120

0.00



QC21 - Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

PR
10/10/07
see 30
PR
11/02/07
MF
10-10-22

Dart Aerospace Ltd

W/O: 38798-1		WORK ORDER CHANGES						
DATE	STEP	Perm.	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/07	#100	ADD	steps to Powder coat Per Q2 004 ADD it up Date w/o + Bom.					10/10/07
10-10-19	#107		Powder coat As per Q2 004 [white @ 320°F. (7/10/19)] start 11:15 Fin 11:45 M 1152016. Temp 11:45 Mask All Androgen part.	BR.	10-10-19	3	11/02-07	10/10/07
	#109	QC3						10/10/07

Part No: D23014 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

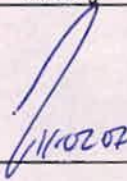
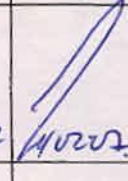
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Open A Part for Day. D2304 to ADD Dims And Finish.						

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O: 38798-1

WORK ORDER CHANGES

DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/07	100	open Dims	A PAR to update Day 02304. to ADD + Finish	JA	10.10.28	PAR 10-59		

Part No: D2304

PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 26, 2009 10:29:19 AM

Work Order ID: 38798

Parent Item: D2304RevB

Parent Item Name: Aspirator Assembly

Comments:



Start Date: 15/07/2009

Required Date: 15/07/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ZWIP		Purchased	No				Each	-	1,719.3500			
Opening WIP BALANCE MATERIAL COST D2294RevA		Manufactured	No			100	Each	0.0000	4.0000			
Perforated sheet D2295RevB		Manufactured	No			100	Each	0.0000	4.0000			
Heater Outer Skin D2301RevA		Manufactured	No			100	Each	0.0000	4.0000			
Insulation Filter D2313RevD		Manufactured	No			100	Each	0.0000	4.0000			
Intake Weldmont D2319RevB		Manufactured	No			100	Each	0.0000	4.0000			
Outlet Weldment D2375-4-16-163RevA		Manufactured	No			100	Each	0.0000	4.0000			
Insulation MS20470AD4-6		Purchased	No			100	Each	0.0000	84.0000			
Rivet, Universal Head												

B 30578

B 3840 ①
B 30579 ③

B 38808

B 50295

B 58043

B 39097

N/A

SB 10/10/07

Friday, 25/04/2008 11:39:41 AM
Julie Lecocq

Process Sheet

Part Number	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR ASSEMBLY
Part Number	: 38798		
Part Number	: 10938		
Part Number	:	Part Number	: D2304
Issue Date	: 25/04/2008 S.O. No. :	Drawing Number	: D2304 REV B
Part Rev.	: NC	Project Number	: N/A
First Issue	: 25/04/2008 Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u>W</u>	Due Date	: 05/05/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	: Est. C 00.12.05 Re-format EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2294	Perforated sheet
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Perforated sheet

Pick:

Qty	Part Number	Description	Batch
1	D2294	Perforated sheet	3839 1x

30578 3x - W

2.0	D2295	Heater Outer Skin
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Heater Outer Skin

Pick:

Qty	Part Number	Description	Batch
1	D2295	Outer skin	3839 1x

30578 3x - W

3.0	D2301	Insulation Filter
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Insulation Filter

Pick:

Qty	Part Number	Description	Batch
1	D2301	Insulation filter	38808

AS 08/10/07 (x4)

4.0	D2313	Intake Weldmont
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Intake Weldmont Assy

Pick:

Qty	Part Number	Description	Batch
1	D2313	Intake ass'y	38808

AS 08/10/07 (x4)

AS 08/10/07 (x4)

WORK ORDER CHANGES

W/O: 38798

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/02	100	asking for MS20470ADY-6 but need MS 20600 AD 4W 2 M111636 MS 20600 AD 4W 3 M111636 MS 20600 AD 4W 4 M115573 PERMANENT CHG: CAN'T INSTALL, NO ACCESS	SA	10/09/02	3	10.09.02	

Part No: D2304 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Date & initial all entries

Friday, 25/04/2008 11:39:41 AM
Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 38798

Part Number: D2304

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2319

Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Outlet Weldment

Pick:

Qty Part Number Description Batch
1 D2319 Outlet ass'y

Batch

B3F80S

est. B58063 (4)
C 8/1/24 (4)

6.0

D2375416163

Insulation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Insulation

Pick:

Qty Part Number Description Batch
1 D2375-4-16-163 Insulation

Batch

39597

C 8/1/24 (4)

7.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 21.0000 Each(s)/Unit Total: 84.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch
21 MS20470AD4-6 Rivet

Batch

M107082

B 8/1/28

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2304

SB 10/10/07 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





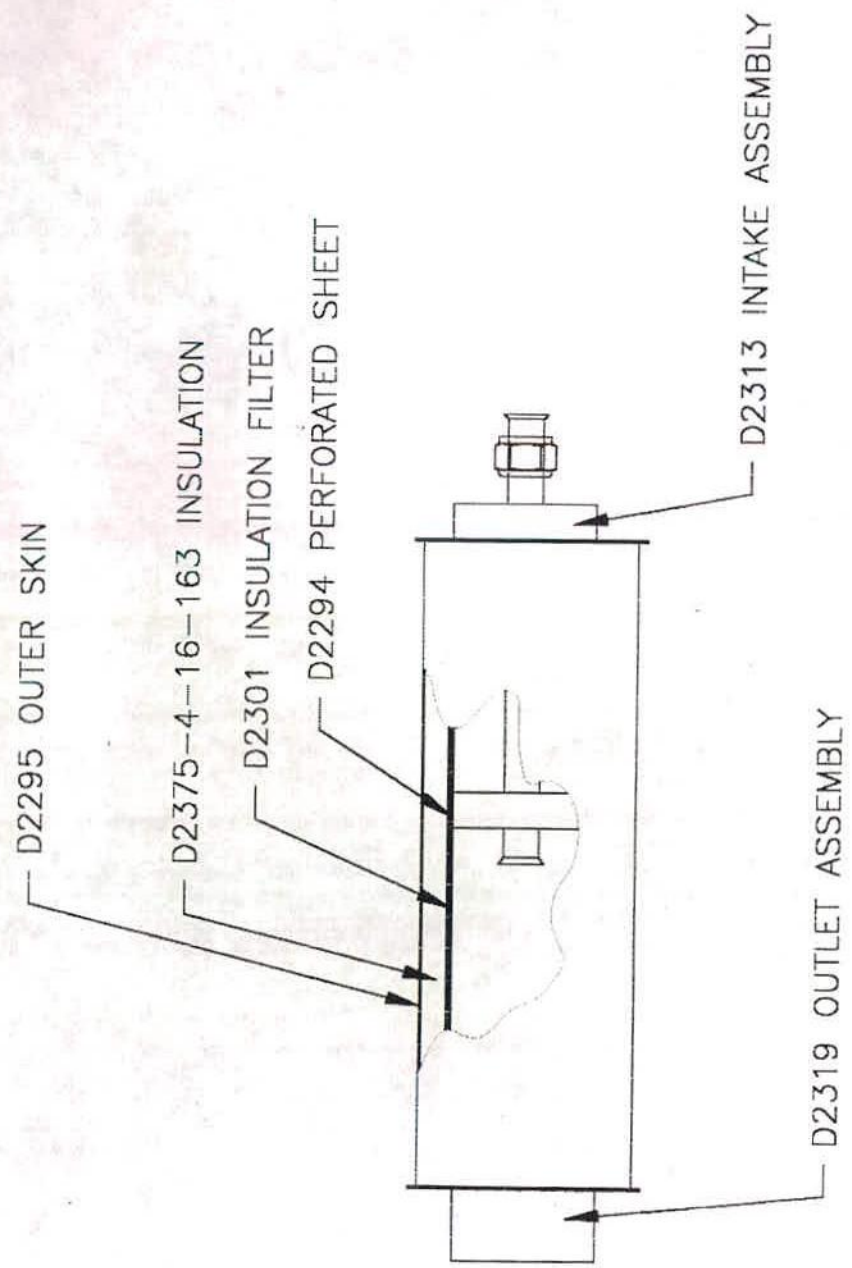
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>JS</i>	DRAWING NO. D2304	REV. B SHEET 1 OF 2
DATE 96:02:27		TITLE ASPIRATOR ASSEMBLY	SCALE 1:1
B	96:02:27	REMOVAL OF REVISION DESCRIPTION	

QTY	Part No.	Description
X	D2304	B205 ASPIRATOR ASSEMBLY
1	D2294	PERFORATED SHEET
1	D2295	OUTER SKIN
1	D2301	INSULATION FILTER
1	D2313	INTAKE ASSEMBLY
1	D2319	OUTLET ASSEMBLY
1	D2375-4-16-163	INSULATION
A/R	MS20470AD4-6	Rivets

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38798



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. B
CHECKED	APPROVED	D2304	SHEET 2 OF 2
DATE		TITLE	SCALE
95:01:03		ASPIRATOR ASSEMBLY	



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